

**Work Order ID 52910**

October 19, 2009 12:43:41 PM



Page 1

Item ID: D2571

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 10/19/09 Start Qty: 6.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 6.00



Customer:

**Reference:**Approvals: Process Plan: *PL*Date: *10-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	Memo	0.00	88 09/10/22	10 09/10/22
D2571	Rev E	HAAS CNC VERTICAL MACHINING #1	0.00		
100		HAAS I	0.00		
		HAAS CNC vertical machine #1	0.00		
		Program Batch No. <i>52910</i> Double check by: <i>H.A.</i> 1-Machine Step No per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect			
110		CONVENTIONAL MILLING MACHINE	0.00		
		Mill Conv	0.00		
		Conventional Milling Machine	0.00	<i>88 09/10/22</i>	<i>10 09/10/22</i>
120		QC2- Inspect parts off machine FAI/FAIB	0.00	<i>88 09/10/22</i>	<i>10 09/10/22</i>
		QC	0.00		
		Quality Control			

# Work Order ID 52910



Page 2

October 19, 2009 12:43:41 PM

Item ID: D2571

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 10/19/09 Start Qty: 6.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

20 09/10/26

10 Ø

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

10 09/10/27

Ø

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M112260

0.00

→ 10 09/10/27 10 Ø

Memo

START TIME: 11:00 AM FINISH TIME: 11:30 AM

OVEN TEMPERATURE: 320°

**Work Order ID 52910**

Page 3

October 19, 2009 12:43:41 PM

Item ID: D2571

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 10/19/09 Start Qty: 6.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 6.00



Customer:

**Reference:**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

160



QC

Quality Control

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

BL 09-10-27

0.00

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

433

0.00

9/10/28

TOSL

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/10/29  
BL 09-10-28

# Picklist Print

October 19, 2009 12:43:45 PM

Page 1

Work Order ID: 52910



Parent Item: D2571RevE



Parent Item Name: Saddle, Fwd Out 205

Start Date: 10/19/09

Required Date: 11/02/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007RevB		Manufactured		No		100	Each	0.0000	6.0000			

Saddle Billet



Batch # 346412

ord 09/01/21

10

DART AEROSPACE LTD				Work Order:	52910
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

16f3

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.439	.440	.440		
B	1.745	1.755		1.749	1.749	1.750	1.750		
C	3.495	3.505		3.499	3.499	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		.503	.503	.502	.503		
G	0.257	0.262		.259	.259	.259	.260		
H	0.375	0.380		.377	.377	.377	.378		
I	0.490	0.510		.501	.501	.502	.499		
J	1.174	1.184		1.178	1.178	1.177	1.178		
K	0.558	0.578		.566	.567	.567	.565		
L	1.174	1.184		1.177	1.178	1.177	1.178		
M	1.490	1.500		1.493	1.494	1.494	1.495		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	3.869	3.879		3.873	3.873	3.874	3.874		
P	0.115	0.135		.124	.122	.122	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.249	.257		
S	0.115	0.135		.128	.131	.132	.133		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.959	2.959	2.960		
V	0.230	0.250		.236	.239	.238	.237		
W	0.115	0.135		.115	.117	.116	.127		
X	0.308	0.313		.312	.312	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.633	.623	.623	.621		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.243	.247	.247	.246		
AE	1.375	1.395		1.389	1.387	1.387	1.389		
AF	0.115	0.135		.135	.135	.133	.135		
AG	0.240	0.280		.250	.260	.250	.248		
AH	0.240	0.260		.246	.249	.248	.247		
AI	2.000	2.020		2.002	2.000	2.000	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	<i>John</i>	Audited by:	<i>John</i>
Date:	09/10/21	Date:	09/10/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>John</i>	<i>John</i>

DART AEROSPACE LTD				Work Order:	
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	20/3

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.503	.503		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.493	.493	.500	.500		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.128	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.252	.251		
S	0.115	0.135		.128	.130	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.961	2.961	2.961		
V	0.230	0.250		.238	.239	.238	.239		
W	0.115	0.135		.125	.125	.121	.127		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.386	1.386	1.384	1.385		
AF	0.115	0.135		.125	.125	.131	.131		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.250	.248	.249		
AI	2.000	2.020		2.001	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	88	Audited by:	51
Date:	09/10/22	Date:	09/10/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	28 JLM

DART AEROSPACE LTD			Work Order:	
Description: Saddle, Fwd Outboard			Part Number:	D2571
Inspection Dwg: D2571 Rev. E			Page 1 of 1	30/3

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					By	Date
				1	2	3	4			
A	0.438	0.443		.440	.440					
B	1.745	1.755		1.750	1.750					
C	3.495	3.505		3.500	3.500					
D	1.745	1.755		1.750	1.750					
E	7.990	8.010		8.000	8.000					
F	0.490	0.510		.504	.508					
G	0.257	0.262		.259	.259					
H	0.375	0.380		.377	.377					
I	0.490	0.510		.500	.500					
J	1.174	1.184		1.180	1.180					
K	0.558	0.578		.570	.570					
L	1.174	1.184		1.180	1.180					
M	1.490	1.500		1.495	1.495					
N	2.495	2.505		2.500	2.500					
O	3.869	3.879		3.874	3.874					
P	0.115	0.135		.125	.127					
Q	0.115	0.135		.135	.135					
R	0.240	0.260		.248	.251					
S	0.115	0.135		.130	.130					
T	0.178	0.198		.188	.188					
U	2.940	2.980		2.960	2.960					
V	0.230	0.250		.238	.238					
W	0.115	0.135		.130	.125					
X	0.308	0.313		.310	.310					
Y	0.760	0.765		.760	.760					
Z	0.352	0.372		.364	.364					
AA	0.470	0.530		.500	.500					
AB	0.615	0.635		.630	.630					
AC	0.053	0.073		.063	.063					
AD	0.240	0.260		.250	.250					
AE	1.375	1.395		1.384	1.384					
AF	0.115	0.135		.135	.135					
AG	0.240	0.280		.260	.260					
AH	0.240	0.260		.248	.246					
AI	2.000	2.020		2.020	2.020					
AJ	0.023	0.043		.033	.073					

Accept/Reject

Measured by:	<i>SL</i>	Audited by:	<i>SL</i>
Date:	<i>09/02/27</i>	Date:	<i>09/02/26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>SL</i>	<i>SL</i>

